



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4895-045
Job Sheet 181264



Part No: D4895-045

Job Qty: 2 ea

Part Name: Fwd Outboard Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A 14.07.25 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Waterjet		2 12/07/28
100	Waterjet	2 pcs	8/31/18	8/31/18	0.00	1.68	Waterjet1		2 12/07/28
110	CNC Vertical Machining	2 pcs	8/31/18	8/31/18	1.13	6.67	HAAS1-5		DSP
120	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Machining-3		DSP
150	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC8 Machining-3		1/10 18/8/8
160	HandFinish	2 pcs	8/31/18	8/31/18	0.00	0.49	HandFinish1		D.R 18-08-8
170	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC7-4		M 18-08-16
171	Powdercoat	2 pcs	8/31/18	8/31/18	0.00	0.24	Powdercoat1		21 18-08-DAS
172	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC3		AUG 29 2018 68
180	Small Fab	2 pcs	8/31/18	8/31/18	0.00	0.37	Small Fab-8		SEP 12 2018 68
190	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC5		SEP 12 2018 68
200	Packaging	2 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-2	ST 448	SEP 14 2018
210	QC21-SA	2 Ea	8/31/18	8/31/18	0.00	0.00	QC21		SEP 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	6.0200 ft (3.01 ea)	90-Start up Operation	FM 1355 16/5046508
D4859-1	Bushing	8 Ea (4 ea)	180-Small Fab	5097596

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X12.000	6	24	0
180-Small Fab	D4859-1	8	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐																																																						
Date : _____	Step #: _____	MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																						
Dart Aerospace Ltd. 1270 Aberdeen Street Hewitsonbury, ON L6A 1K7 CANADA TEL.: 1 613 832-6200 Email: sales@dartaero.com www.dartaerospace.com Container No: S097170 Part: D4895-045 Job No: 181264 Serial No/Batch: S097170 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 07/28/18																																																								
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OTHER : _____																																																								

DART AEROSPACE LTD		Work Order: 181264
Description: Fwd Outboard Beam		Part Number: D4895-5
Inspection Dwg: D4895	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC Milling	32.55	+/-0.030	32.550				
	R0.38	+/-0.030	0.380				
	0.85	+/-0.030	0.855				
	0.93	+/-0.030	0.907				
	8.32	+/-0.030	8.318				
	Ø0.425	+0.000/-0.002	0.424				
	0.750	+/-0.010	0.748				
	0.200	+/-0.010	0.199				
	R0.43	+/-0.030	0.430				
	3.00	+/-0.030	3.000				
	3.50	+/-0.030	3.500				
	0.15	+/-0.030	0.149				
	0.250	+/-0.010	0.249				
	5.75	+/-0.030	5.749				
	1.34	+/-0.030	1.342				
	1.00	+/-0.030	1.005				
	R0.13	+/-0.030	0.125				
	0.150	+/-0.010	0.156				
	1.15	+/-0.030	1.148				
	3.00	+/-0.030	2.999				
	Ø0.377	+0.006/-0.001	0.380				
	3.50	+/-0.030	3.499				
	1.75	+/-0.030	1.750				
	3.600	+/-0.005	3.600				
	1.800	+/-0.005	1.800				
	0.80	+/-0.030	0.800				
	0.60	+/-0.030	0.600				
	2.300	+/-0.005	2.300				
	Ø1.00	+/-0.030	1.000				
Manual Mill	0.25	+/-0.030	0.250				
	5.50	+/-0.030	5.500				
	12.000	+/-0.005	12.000				
	1.55	+/-0.030	1.550				
	Ø0.465 X 90°	+/-0.010 x 0.5°	0.465 x 90°				
	R0.25	+/-0.030	0.250				
	0.500	+/-0.010	0.500				

Measured by: DDP	Audited by:	Preliminary Approval:
Date: 18/07/20	Date: 18/07/20	Date:
Rev	Date	Change
A	14.08.05	New Issue
Revised By	Approved	
KJ	[Signature]	